



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6505G00431-3T
Job Sheet 190236



Part No: RBW6505G00431-3T

Job Qty: 1 pcs

Part Name: AW139 Trd Support Bearing Repair Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6505G00431-3T Rev.3 IPP Rev. A 19.02.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - 1	1 pcs	3/18/19		0.00	0.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
100	Small Fab - 2 - B4B	1 pcs	3/18/19		0.00	1.00	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	1 pcs	3/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Container No: S194234



Part: RBW6505G00431-3T

Job No: 190236

Serial No/Batch: S194234

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/26/19

DAS
40
9-89

JUN 27 2019

Plex 2/14/19 11:49 AM Dart.Hadley.Shannon

				QC 5 - 30	
130	Packaging 3-1 - Stock - B4B	1 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	1 pcs	3/18/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53

DAS
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JUN 28 2019

DAS
70
9-89

RB-
Floor
RIGHT

Part Op 90 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-
 Descriptions: 1510-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW6505G00431-3T-13 to RBW6505G00431-3T-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 APP-1510-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW6505G00431-3T-13 to RBW6505G00431-3T-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1510-E	Case	1 Ea (1 ea)	90-Small Fab - 1	5140368
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 2 - B4B	3021040
RBW6500X01611W142B-3T	Shaft Support Bearing Removal	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5166737
RBW6505G00431-3T-11	Bottom Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5140372
RBW6505G00431-3T-13	Contents Placard	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5154419
RBW6505G00431-3T-9	Lid Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5140375
RBW6510A00436W142B-3T	Bearing Assembly Press/Support Tool	1 pcs (1 ea)	100-Small Fab - 2 - B4B	3029070
RBW6510A00436W142C-3T	Shaft Support Tool Bearing Support Housing	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5179051
RBW6510A00436W142D-3T	Wrench, Shurlock, Bearing Support Housing	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5183698
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - 2 - B4B	5163939

010627

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	APP-1510-E	1	1	0
	97524A032	4	502	0
100-Small Fab - 2 - B4B	RB41011	1	413	0
	RBW6500X01611W142B-3T	1	0	0
	RBW6505G00431-3T-11	1	1	0
	RBW6505G00431-3T-13	1	0	0
	RBW6505G00431-3T-9	1	1	0
	RBW6510A00436W142B-3T	1	0	0
	RBW6510A00436W142C-3T	1	0	0
	RBW6510A00436W142D-3T	1	0	0

Part Specifications

Specifications could not be found.

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Job Sheet 190236



Part No: RBW6505G00431-3T

Job Qty: 1 ea

Part Name: AW139 Trd Support Bearing Repair Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6505G00431-3T Rev.3 IPP Rev. A 19.02.01 New issue DP Verify DD

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100	Small Fab - 1	1 pcs	3/18/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/18/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC21-FG	1 Ea	3/18/19	0.00 0.00	QC 21 - FG - 21

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1510-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
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 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1510-E	Case	1 Ea (1 ea)	100-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 1	
RBW6500X01611W142B-3T	Shaft Support Bearing Removal	1 pcs (1 ea)	100-Small Fab - 1	
RBW6505G00431-3T-11	Bottom Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 1	
RBW6505G00431-3T-13	Contents Placard	1 pcs (1 ea)	100-Small Fab - 1	
RBW6505G00431-3T-9	Lid Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 1	
RBW6510A00436W142B-3T	Bearing Assembly Press/Support Tool	1 pcs (1 ea)	100-Small Fab - 1	
RBW6510A00436W142C-3T	Shaft Support Tool Bearing Support Housing	1 pcs (1 ea)	100-Small Fab - 1	
RBW6510A00436W142D-3T	Wrench, Shurlock, Bearing Support Housing	1 pcs (1 ea)	100-Small Fab - 1	
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	97524A032	4	526	0
	APP-1510-E	1	1	0
	RB41011	1	423	0
	RBW6500X01611W142B-3T	1	0	0
	RBW6505G00431-3T-11	1	1	0
	RBW6505G00431-3T-13	1	0	0
	RBW6505G00431-3T-9	1	1	0
	RBW6510A00436W142B-3T	1	0	0
	RBW6510A00436W142C-3T	1	0	0
	RBW6510A00436W142D-3T	1	0	0

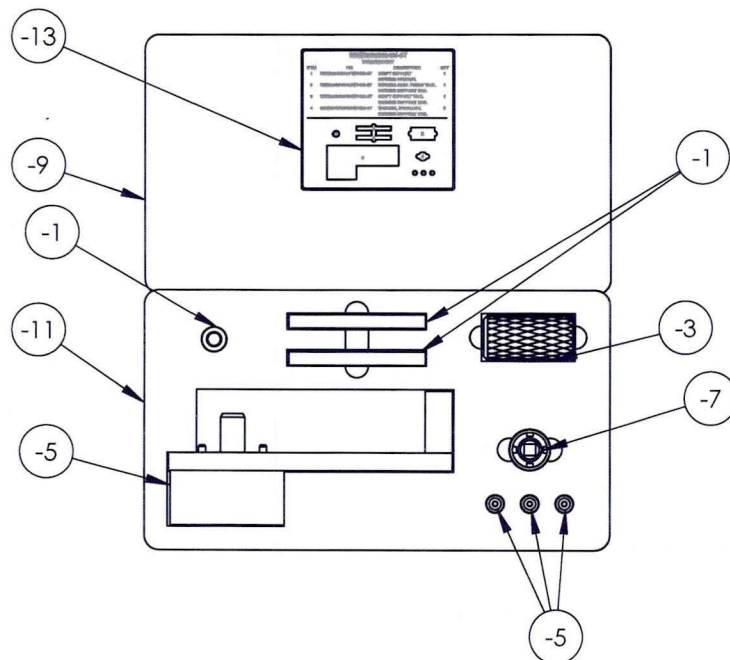
Part Specifications

Specifications could not be found.

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	SHT 3 MODIFIED CUTOUTS. SHT 4 CORRECTED QTYS TO 1, ADDED ITEM NUMBERS ON LAYOUT VIEW	2/6/2012	JAG	
2	-13 CH'D MATERIAL WAS ALUMINUM IS PLASTIC. -9 ADDED CUTOUT FOR CLEARANCE TO BOTTOM OF FOAM.	3/12/2013	BIM	RJC
3	-13 CORRECTED P/N'S, WAS RBW6500X01611W142B-3T IS RBW6500X01611W142B-3T.	5/19/2014	JAG	RJC



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 190236 *MS*
190206

REF P/N 3T6505G00431

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	SHAFT SUPPORT BEARING REMOVAL		RBW6500X01611W142B-3T	1
		-3	1	BEARING ASSEMBLY PRESS TOOL, BEARING SUPPORT HOUSING		RBW6510A00436W142B-3T	1
		-5	1	SHAFT SUPPORT TOOL, BEARING SUPPORT HOUSING		RBW6510A00436W142C-3T	1
		-7	1	WRENCH, SHURLOCK, BEARING SUPPORT HOUSING		RBW6510A00436W142D-3T	1
	B/O	-9	1	LID FOAM	C200, BLACK, FLAT	1-3/4 X 11-1/4 X 20-1/8	2
	B/O	-11	1	BOTTOM FOAM	Y20, BLACK	5-5/8 X 11-1/4 X 20-1/8	3
	B/O	-13	1	CONTENTS PLACARD	PLASTIC	1/16 X 6 X 6-1/2	4
	B/O	-15	1	RED BARN PLACARD	ALUMINUM	RB41009	NS
	B/O	-17	1	PELICAN CASE	PLASTIC	BLACK, PELICAN #APP-1510-E	NS

 RED BARN MACHINE	
TITLE	
TRD SUPPORT TOOL KIT	
DWG NO.	REV
RBW6505G00431-3T	3
MATL	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH
	SPEC
	USED ON MODEL
	AW139
SCALE 1:8	DATE 10/14/2011
	SHEET 1 OF 4

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					